



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11) Publication number : **0 512 904 A2**

(12)

## EUROPEAN PATENT APPLICATION

(21) Application number : **92401240.4**

(51) Int. Cl.<sup>5</sup> : **A47G 27/02, B60N 3/04,  
B29C 43/14**

(22) Date of filing : **30.04.92**

(30) Priority : **03.05.91 US 694966  
23.04.92 US 872456**

(43) Date of publication of application :  
**11.11.92 Bulletin 92/46**

(84) Designated Contracting States :  
**AT BE CH DE DK ES FR GB GR IT LI LU MC NL  
PT SE**

(71) Applicant : **THE AKRO CORPORATION  
1212 Seventh Street, S.W.  
Canton, Ohio 44771 (US)**

(72) Inventor : **Reuben, Harold  
231 Benson Road  
Akron, Ohio 44313 (US)**

(74) Representative : **Orès, Bernard et al  
Cabinet ORES 6, Avenue de Messine  
F-75008 Paris (FR)**

(54) Floor mat and method of making same.

(57) The floor mat of the present invention is a pliable multilayer structure having an upper face layer and a base layer. The base layer has a main body section bordered by an edge section. Preferably, the main body section is relatively thin and the edge section is relatively thick. A surface of the base layer is adapted to confront flooring overlaid by the mat. The edge section has a channel extending longitudinally thereof, and preferably opening from the bottom surface of the edge section. A portion of the main body section can have a channel molded therein such that a portion of the main body section is disposed above the remainder of the main body section to provide a decorative and aesthetically pleasing design in the main body section.

EP 0 512 904 A2

### Background of the invention

This invention relates to floor mats such as those used in the passenger compartments of automobiles or as entry mat in homes or workplaces.

Floor mats of this type found in automobiles or homes generally are made of a combination of an elastomeric material (e.g., rubber) and a carpeted material. Typically the carpeted material is attached to a rubber backing layer by any of various methods. Unfortunately the layers of these mats tend to separate at the edges of the mat when the mat is in use.

Various methods have been used to provide additional strength to the attachment between layers of the mat to prevent the separation of the mats layers at the edge. For example, methods include surging yarn over the edges of the mat or a tape may be placed covering the edge of the mat and then stitched to the mat. A disadvantage of these methods is that the stitching holding the edging tape to the mat also tends to wear out with use and the tape separates from the mat. Furthermore, the tape and stitching must be added to the mat after the mat has been molded, thereby adding an additional manufacturing step.

Another problem is that the mats have a tendency to move or shift due to the action of feet on the mat. Various efforts have been made to prevent slippage by use of permanent retention means such as hooks, snap fasteners, Velcro® strips and the like. However, none of these are commercially successful because they tend to distract from the aesthetics of the mat. Another solution, particularly for mats used in automobiles, is to use an array of downwardly extending projections or "nibs" to reduce slippage such as proposed, for example in commonly assigned U.S. Patent No. 4,174,991 to Reuben. An alternative solution is to use a tacky adhesive on the undersurface of the mat such as proposed in U.S. Patent No. 4,609,850 to Rockett et al. A combination of nibs and tacky adhesive has also been proposed in commonly assigned U.S. Serial No. 07/642,926 filed January 18, 1991, and a combination of nibs and polyurethane foam has been proposed in commonly assigned U.S. Serial No. 07/687,234 filed April 18, 1991.

It would be highly desirable to provide a floor mat which does not have the need for edge stitching, taping, or the like while eliminating the slippage problems associated with conventional floor mats.

### Summary of the Invention

The floor mat of the present invention is a pliable multilayer structure having an upper face layer and a base layer adapted to confront flooring overlaid by the mat. The base layer has a main body section bordered by an edge section. Preferably, the main body section is relatively thin and the edge section is relatively thick. The edge section has a channel extending long-

itudinally thereof, and preferably opening from the bottom surface of the edge section. The edge section has an upper surface disposed at an elevation above the elevation of the main body section of the base layer. This upper surface preferably provides a decorative edge portion in the face layer. The thicker edge section provides stiffness to the periphery of the base layer and serves to reduce deformation of the channel of the mat during use. Additionally, the thicker section helps prevent slippage of the mat. The channel of the floor mat preferably has a plurality of ribs disposed within and extending transversely across the channel to further stiffen the channel. A portion of the main body section can also have a channel molded therein, and preferably opening from the bottom surface of the main body section of the base layer. This portion of the main body section is disposed at an elevation above the elevation of the remainder of the main body section. This raised portion provides a decorative and aesthetically pleasing design in the main body section.

The floor mat may, and preferably does, include anchoring means to assist in preventing slippage. For example, the floor mat can include a plurality of nibs extending downward from the bottom surface of the base layer, an adhesive layer on the bottom surface of the base layer, a layer of polyurethane foam having a high coefficient of friction, or any combination thereof.

The present invention further encompasses a method of producing a floor mat having the above pliable multilayer structure. The method includes contacting the top surface of the base layer to the bottom surface of the upper face layer and placing the layers under a compressive molding pressure applied to the bottom surface of the base layer and the top surface of the base layer. A channel is molded in, and preferably opens from, the edge section of the base layer while the base layer and the upper face layer are under compressive molding pressure. A portion of the bottom surface of the face layer is embedded in the top surface of the upper face layer. The base layer is heated while it and the face layer are under the compressive molding pressure to join the layers together and to cure the base layer.

### Description of the Drawings

other features of the invention will be apparent from the following description of illustrative embodiments thereof, which should be read in conjunction with the accompanying drawings, in which:

Fig. 1 is a top perspective view of a floor mat in accordance with the invention;

Fig. 2 is a bottom perspective view of the mat;

Fig. 3 is an enlarged fragmentary sectional view taken substantially along the line and in the direction of the arrows 3-3 of Fig. 1;

**Fig. 4** is a perspective view of the mat illustrating the pliable nature of the mat;

**Fig. 5** is a fragmentary bottom plan view of an alternative embodiment of a floor mat in accordance with the present invention;

**Fig. 6** is an enlarged fragmentary sectional view taken substantially along the line and in the direction of the arrows 6-6 of **Fig. 5**;

**Fig. 7** is a fragmentary bottom plan view of a floor mat in accordance with the present invention; and **Fig. 8** is a fragmentary sectional view taken substantially along the line and in the direction of the arrows 8-8 of **Fig. 7**;

**Fig. 9** is a fragmentary sectional view illustrating another embodiment of the invention;

**Fig. 10** is a top perspective view of a household floor mat in accordance with the invention;

**Fig. 11** is a bottom perspective view of the floor mat shown in **Fig. 10**.

#### Description of the Preferred Embodiment

The present invention now will be described more fully hereinafter with reference to the accompanying drawings, in which preferred embodiments of the invention are shown. This invention can, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein; rather, applicant provides these embodiments so that this disclosure will be thorough and complete, and will fully convey the scope of the invention to those skilled in the art.

Referring now more particularly to the drawings, the pliable multilayer floor mat of the present invention is indicated generally by the numeral 10. The term "pliable" relates to the mat being easily folded or flexed and is illustrated in **Figure 4**. For example, a floor mat held at arm's length which is unable to support its own weight would be pliable or a mat which can be rolled up would be pliable. The floor mat includes an upper face layer 12 overlying a base layer 15 the base layer 15 having an upper surface 17 and a bottom surface 19. The bottom surface 19 is adapted to confront flooring overlaid by the mat. The base layer 15 further includes a relatively thin main body section 20 bordered by a relatively thick edge section 21 as compared to each other. The edge section 21 of the base layer 15 has a channel 22 extending longitudinally thereof, and preferably opens from the bottom surface 19 of the base layer 15.

The upper face layer 12 preferably is formed from carpet material which is wear-resistant and has a pleasing appearance. It will be apparent to one skilled in the art that the face layer can be an elastomer layer 12a (**Figure 9**), a thermoplastic layer, such as a vinyl compound, or a non-woven layer. The carpet material may be tufted, woven, needle punched or the like, and may be backed or unbacked. Preferably, the carpet

material is a tufted pile carpet construction, i.e., a plurality of pile yarns extend through a primary backing to form loops which are cut to form tufts. The fibers of the pile yarns can be composed of natural or synthetic fibers and may be thermoplastic or thermosetting. The carpet fibers employed in the present invention are described in U.S. Patent No. 4,174,991 to Reuben, the disclosure of which is incorporated herein by reference as if set out fully, and include polyamide fibers such as nylon fibers, particularly nylon 6 and nylon 66, polyester fibers, acrylic fibers, polypropylene and blends and copolymers thereof.

The base layer 15 is preferably formed of a heat curable elastomeric material or a thermoplastic material. Exemplary heat curable elastomeric materials include vulcanizable elastomers which are cured by a sulfur reaction mechanism or a metallic oxide mechanism. Particularly suitable elastomeric materials are rubbers such as natural rubber, butadiene polymers and copolymers such as styrene-butadiene rubbers and polybutadiene rubbers, isoprene polymers and copolymers, chloroprene rubbers such as neoprene, nitrile rubbers, butyl rubbers, and ethylene-propylene rubbers, and blends and copolymers thereof. Styrene-butadiene rubbers are particularly preferred for use in the present invention. Suitable thermoplastic materials include polyvinyl chloride, polyethylene, ethylene vinyl acetate, polypropylene, polystyrene, and thermoplastic rubber.

As shown in **Figures 1-3**, the channel 22 circumscribes the periphery of the floor mat 10. The upper surface 23 of edge section 21 is disposed at an elevation above the elevation of the main body section 20. Preferably, this elevated upper surface 23 of the base layer 15 provides a decorative and aesthetically pleasing edge portion 24 to the face layer 12 of the floor mat 10, and eliminates the need for stitching or binding of the edge of the mat. The elevated upper surface 23 of edge section 21 reduces the tendency of the uppermost face layer 12 to separate from the base layer 15. The decorative edge portion 24 of the face layer 12 is preferably about 1/4 inches high, but heights from about 1/8 to about 1/2 inches may be used.

As illustrated in **Figure 3**, the channel 22 is formed in and preferably opens from the bottom surface 19 of the base layer 15. Preferably, the channel 22 assists in creating the thicker edge section 21 of the base layer 15. As described below, a thicker edge section 21 of the floor mat may optionally result from the redistribution of base layer material during the molding, particularly compression molding of the floor mat. This thicker edge section 21 also prevents the mat 10 from slipping during use.

The shape of the channel 22 is shown as substantially rectangular in **Figures 1-8** and as a tapered channel in **Figure 9**, but may be of other shapes such as V-shaped or U-shaped or semicircular. The chan-

nel 20 is preferably about 1/4 inches wide and about 1/4 inches deep, however, suitable dimensions for the channel are typically from about 1/8 to about 1/2 inches wide and from about 1/8 to about 1/2 inches deep. When in use, the bottom surfaces of the main body portion 20 and the edge section 21 of the base layer 15 are, as shown in Figures 3 and 6, substantially coplanar. The bottom surface 19 of the base layer 15 which extends outward from the channel 22 to the edge of the floor mat 10 and the bottom surface 15 of the base layer 15 which extends inward from the channel 20 both are closely adjacent and preferably underlying surface of the flooring.

As shown in Figures 3, 6, 8, and 9 the present invention may optionally have a step portion 27 extending from the outer edge of the thicker edge section 21 of the base layer 15. The width of the step portion 27 is preferably less than one inch and more preferably greater than 1/16 inch. The step portion 27 of the floor mat extends outward from the edge section 21 to the edge of the floor mat 10, and during use the bottom surface of the step portion 27 is substantially coplanar with the portion of the bottom surface 19 of the base layer 15. The step portion 27 adds area for bonding of the face layer 12 to the base layer 15 thereby increasing the strength of the bond between the layers and increasing the resistance to separation. Furthermore, the step portion 27 provides a smooth edge to the floor mat 10 without the use of binding materials by allowing for the return from the edge section 21 of the base layer 15 to the normal thickness of the base layer 15 and thereby exposing a limited portion of the base layer 15 to view.

In an alternative embodiment of the present invention, as shown in Figures 5, 6 and 9, rib members 30 are disposed in and extend transversely across the channel 22, strengthen the channel 22 and prevent distortion of its shape. The rib members 30 assist in reducing the tendency of the channel 22 of compressing or spreading and causing the edges of the mat 10 to elevate above the surface upon which the mat is placed. The elevation of the edges of the mat 10 above the surface upon which the mat is placed increases the possibility of wear, can present an impediment to ingress and egress of a vehicle or dwelling and can contribute to mat slippage during use. The rib members 30 are shown as spaced approximately one inch apart however, spacings from about 1/2 to about 2 inches may be used.

As shown in Figures 7, 8, and 9, the floor mat 10 preferably includes a plurality of nib elements 32 and/or other anti-slippage anchoring means such as the material 35 shown in Figure 7. The nib elements 32 illustratively and preferably are of frusto-conical shape and are connected to the lower surface of base layer 15. The nib elements 32 extend substantially vertically downward from the base layer 15 and when provided through the material 35 upon the bottom sur-

face of the base layer 15. The material 35 may be a tacky pressure-sensitive adhesive material as described in U.S. Application Serial No. 07/642,926 filed January 18, 1991, or polyurethane foam as described in U.S. Application Serial No. 07/687,234 filed April 18, 1991, the disclosures of which are incorporated herein by reference as if set out fully.

As shown in Figures 10 and 11, the main body section 20 of the floor mat 10 can also have a channel 22a formed in a portion thereof, and preferably opening from a bottom surface 19a of the main body section 20. The upper surface 23a of the portion of the main body section 20 having the channel 22a is disposed at an elevation above the elevation of the remainder of the main body section 20 and is substantially the same elevation as the upper surface 23 of edge section 21. Preferably, this elevated upper surface 23a of the main body section 20 provides a decorative and aesthetically pleasing design in the main body section 20, for example, the umbrella shown in Figures 10 and 11 or indicia of an automobile manufacturer. While a raised portion in the main body of the floor mat has been described, other methods of producing such indicia or design in the main body of the floor mat may be utilized. Examples of other methods which could be used include, but is not limited to, embroidery or other stitching means, variations in color or texture of the face layer material or by impressing into the upper surface or face layer the design or logo.

The method of the present invention includes contacting the upper or top surface 17 of a base layer 15 to the bottom surface of the upper face layer 12 followed by placing the base layer 15 and face layer 12 under compressive molding pressure, (e.g., a pressure selected from the range of 50 psi to about 250 psi). Preferably, if a tufted pile tufted carpet is the upper face layer 12, the pile is crushed while the face layer 12 and the base layer 15 are under the compressive molding pressure. A channel 22 or channel 22a is molded in, and preferably opens from the bottom surface 19 of the base layer 15 or the bottom surface 19a of the main body portion 20 while the upper face layer 12 and base layer 15 are under compressive molding pressure. A portion of the bottom surface of the face layer 12 becomes embedded in the base layer during heating and curing of the base layer 15 at a temperature of from about 250°F to about 400°C while the carpet and base layer are under the compressive molding pressure. The face layer of the multilayered mat 10 is cooled to a temperature of less than 100°F to maintain the fibers of the carpet yarns below a temperature at which the pile become substantially permanently deformed under the applied molding pressure and so as to maintain the resiliency of the face layer 12 upon release of the molding pressure. The cooling is conducted simultaneously while the face layer 12 and base layer 15 are under pressure. The heating of the base layer 15 is maintained until the

elastomeric material or the thermoplastic material of the base layer are cured. A suitable molding apparatus is described more fully in U.S. Patent No. 4,174,991, although other molding techniques, particularly if thermoplastic materials are used, will be apparent to one skilled in the art.

A sufficient compressive molding pressure must be employed in the present invention to achieve a bond between the bottom surface of the face layer 12 and the upper surface 17 of the base layer 15. Sufficient compressive molding pressure is also required to mold the base layer material into the recess in the mold cavity. Thus, for example, sufficient molding pressure must be employed in order to embed the loops of a tufted pile carpet face layer 12 into the base layer 15 and also to insure that the elastomeric base layer 15 is formed into the desired channel 22. Furthermore, sufficient pressure may be required to cause the flow of the base layer material when forming the channel 22 and to form the relatively thick edge section 21 adjacent the periphery of the floor mat 10.

It will be appreciated that a mat in accordance with the present invention can be used upon various flooring having carpeted areas or hard surface areas or both types of areas, such as in automobiles and in households. Additionally, the mat will have a longer useful life and can be used more successfully under wet or dirty conditions than a mat having only conventional anchoring means.

While a preferred embodiment of the invention has been shown and described, this was for purposes of illustration only, and not for purposes of limitation, the scope of the invention being in accordance with the following claims.

## Claims

1. A floor mat comprising:
  - a pliable multilayer structure having an upper face layer overlying a base layer wherein said base layer has a main body section bordered by an edge section;
  - said edge section having a channel extending longitudinally thereof, and having an upper surface disposed at an elevation above the elevation of said main body section of said base layer.
2. A floor mat according to Claim 1 wherein the upper surface disposed at an elevation above the elevation of said main body section provides a decorative edge portion in said upper face layer.
3. A floor mat according to Claim 1 further comprising:
  - a plurality of rib members disposed within and extending transversely across said channel.
4. A floor mat according to Claim 1 further comprising a decorative portion in said upper face layer of said main body section.
5. A floor mat according to Claim 1 wherein said base layer is formed of a heat curable elastomeric material.
6. A floor mat according to Claim 1 wherein said base layer is formed of a thermoplastic material.
7. A floor mat according to Claim 1 further comprising anchoring means comprised of a plurality of elongate nib elements connected to and projecting downwardly from the bottom surface of said base layer.
8. A floor mat as in Claim 7 where said anchoring means further includes said nib elements extending downward through a tacky pressure sensitive adhesive or polyurethane foam layer.
9. A floor mat comprising:
  - a pliable multilayer structure having an upper face layer overlying a base layer wherein said base layer has a relatively thin main body section bordered by a relatively thick edge section;
  - said edge section having a channel extending longitudinally thereof and opening from the bottom surface of said edge section, and having an upper surface disposed at an elevation above the elevation of said main body section of said base layer, and providing a decorative edge portion in said upper face layer.
10. A floor mat according to Claim 9, further comprising:
  - a step portion of said pliable multilayer structure extending outward from said edge section to the edge of said mat, where the bottom surface of said step portion is substantially coplanar with said portion of the bottom surface of the base layer.
11. A floor mat according to Claim 9 further comprising:
  - a plurality of rib members disposed within and extending transversely across said channel.
12. A floor mat according to Claim 9 wherein said base layer is formed of a heat curable elastomeric material.
13. A floor mat according to Claim 9, wherein said base layer is formed of a thermoplastic material.
14. A floor mat according to Claim 9 wherein said face layer is formed from tufted pile carpeting.

15. A floor mat according to Claim 9 further comprising a decorative portion in said upper face layer of said main body section.

16. A floor mat comprising:

a pliable multilayer structure wherein said base layer has an upper face layer overlying a base layer having a relatively thin main body section bordered by a relatively thick edge section; said edge section having a channel extending longitudinally thereof and opening from the bottom surface of said edge section, and having an upper surface disposed at an elevation above the elevation of said main body section of said base layer and providing a decorative edge portion in said upper face layer;

a plurality of rib members disposed within and extending transversely across said channel; and

anchoring means comprised of a plurality of elongate nib elements connected to and projecting downwardly from said bottom surface of said base layer.

17. A floor mat according to Claim 16, further comprising:

a step portion of said pliable multilayer structure extending outward from said edge section where the bottom surface of said step portion is substantially coplanar with said portion of the bottom surface of the edge section.

18. A floor mat according to Claim 16 wherein said base layer is formed of a heat curable elastomeric material.

19. A floor mat according to Claim 16, wherein said base layer is formed of a thermoplastic material.

20. A floor mat according to Claim 16 wherein said face layer is formed from tufted pile carpeting.

21. A floor mat comprising:

a pliable multilayer structure having an upper face layer overlying a base layer wherein said base layer has a main body section bordered by an edge section;

said edge section having a first channel extending longitudinally thereof, and having an upper surface disposed at an elevation above the elevation of said main body section of said base layer; and

said main body section having a second channel in a portion thereof, and having an upper surface in said portion having said second channel, said upper surface disposed at an elevation above the elevation of the remainder of said main body section of said base layer.

22. A floor mat according to Claim 21 wherein the upper surface disposed at an elevation above the elevation of said main body section provides a decorative portion in said upper face layer.

23. A floor mat according to Claim 21 further comprising:

a plurality of rib members disposed within and extending transversely across said channel.

24. A floor mat according to Claim 21 wherein said base layer is formed of a heat curable elastomeric material.

25. A floor mat according to Claim 21 wherein said base layer is formed of a thermoplastic material.

26. A floor mat according to Claim 21 wherein said face layer is formed from tufted pile carpeting.

27. A floor mat comprising:

a pliable multilayer structure having an upper face layer overlying a base layer;

said base layer having a channel in a portion thereof, and having an upper surface in said portion, said upper surface disposed at an elevation above the elevation of the remainder of said base layer.

28. A floor mat according to Claim 27 wherein the upper surface disposed at an elevation above the elevation of said main body section provides a decorative portion in said upper face layer.

29. A floor mat according to Claim 27 further comprising:

a plurality of rib members disposed within and extending transversely across said channel.

30. A floor mat according to Claim 27 wherein said base layer is formed of a heat curable elastomeric material.

31. A floor mat according to Claim 27 wherein said base layer is formed of a thermoplastic material.

32. A floor mat according to Claim 27 wherein said face layer is formed from tufted pile carpeting.

33. A method of producing a floor mat having a pliable multilayer structure having an upper face layer overlying a base layer having a main body section bordered by an edge section;

placing the base layer and the face layer under a compressive molding pressure applied to a bottom surface of the base layer and the top surface of the face layer;

molding a channel in the edge section and

extending longitudinally thereof while the base layer and the face layer are under compressive molding pressure;

embedding a portion of the bottom surface of the face layer in the upper surface of the base layer;

heating the base layer to cure the base layer while the face layer and the base layer are under the compressive molding pressure; and

maintaining the heating of the base layer until the base layer is cured.

34. A method according to Claim 33 where the face layer is comprised of tufted pile carpeting, said process further comprising the step of crushing the carpet pile while the base layer and the face layer are under compressive molding pressure.

35. A method according to Claim 33 where the face layer is comprised of tufted pile carpeting, said process further comprising the step of cooling the face layer to maintain the pile carpeting of the face layer below a temperature at which the carpet pile becomes substantially permanently deformed under the applied molding pressure so as to maintain the resiliency of the carpet pile upon release of the compressive molding pressure, the cooling being conducted simultaneously while the face layer and the base layer are under pressure.

36. A method according to Claim 35 further comprising the step of crushing the carpet pile carpeting while the base layer and the face layer are under compressive molding pressure.

37. A method according to Claim 33 wherein said molding step further comprises molding rib members disposed within and extending transversely across the channel.

38. A method according to Claim 33 wherein said molding step includes forming a relatively thin main body section bordered by a relatively thick edge section.

39. A method according to Claim 33, where the base layer is formed of a heat curable elastomeric material.

40. A method of producing floor mat having a pliable multilayer structure having an upper face layer of tufted pile carpeting and overlying a base layer of a heat curable elastomeric material and having a relatively thin main body section bordered by a relatively thick edge section; said mat having a channel extending longitudinally thereof and opening from the bottom surface thereof, and

having an upper surface disposed at an elevation above the elevation of said main body section of said base layer, said method comprising:

contacting a top surface of the base layer to a bottom surface of the face layer;

placing the base layer and the face layer under a compressive molding pressure selected from the range of about 50 psi to about 250 psi, where the compressive molding pressure is applied to a bottom surface of the base layer and a top surface of the face layer;

molding a channel in and opening from the edge section and extending longitudinally thereof while the base layer and the face layer are under compressive molding pressure to form a relatively thin main body section bordered by a relatively thick edge section;

embedding a portion of the bottom surface of the face layer in the top surface of the base layer;

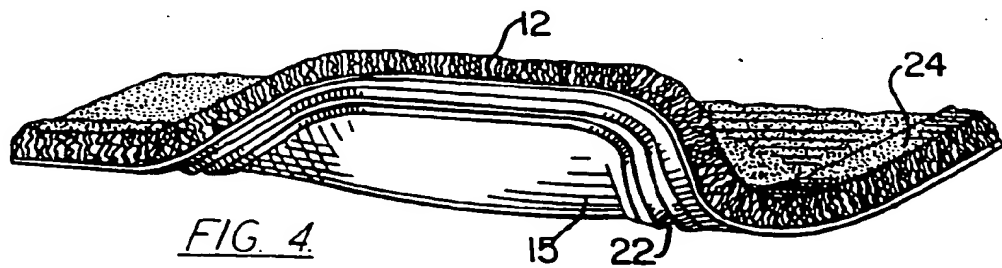
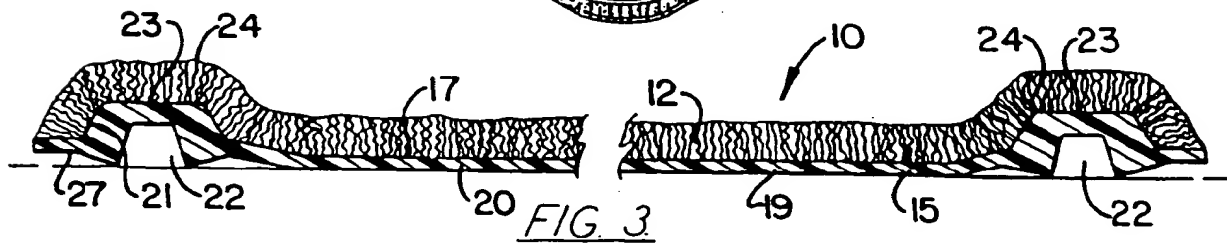
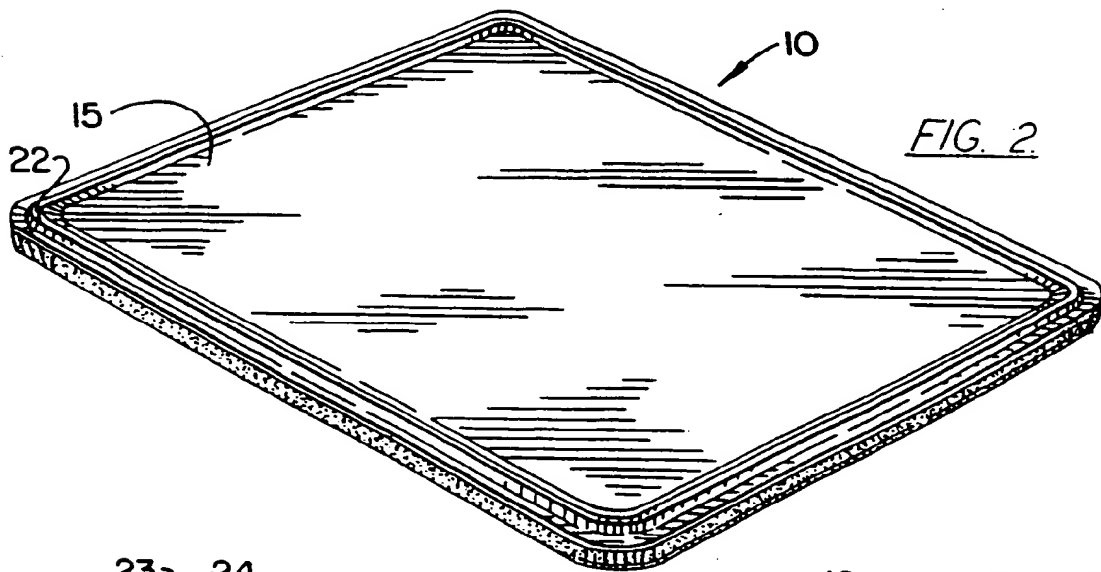
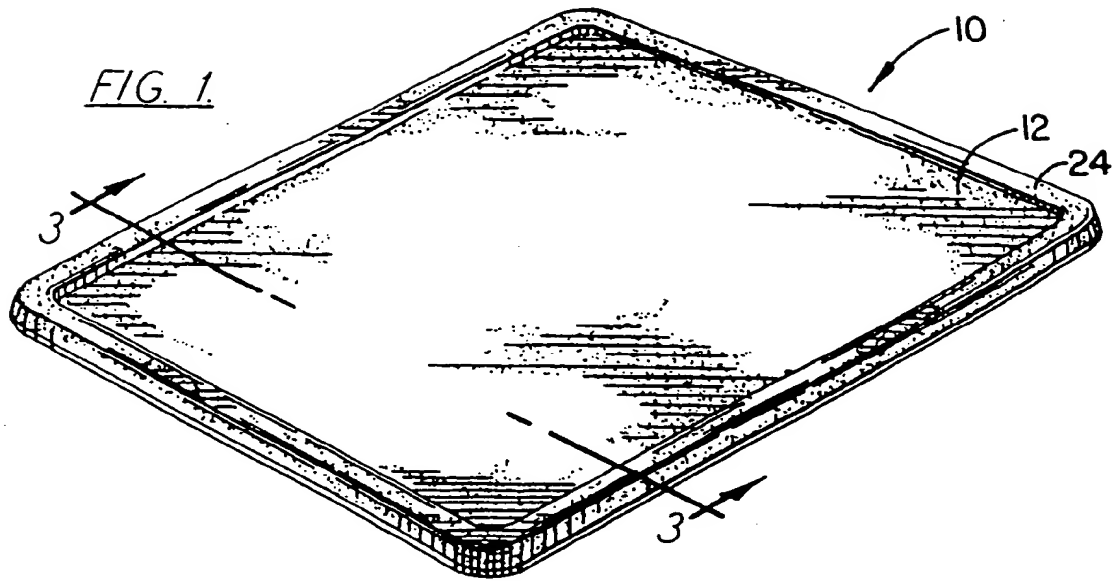
heating the base layer to a temperature within the range of about 250°F to about 400°F to cure the heat curable elastomeric material of the base layer while the face layer and the base layer are under the compressive molding pressure;

cooling the face layer to a temperature less than about 100°F to maintain the pile carpeting of the face layer below a temperature at which the carpet pile becomes substantially permanently deformed under the applied molding pressure so as to maintain the resiliency of the carpet pile upon release of the compressive molding pressure, the cooling being conducted simultaneously while the face layer and the base layer are under pressure; and

maintaining the heating of the base layer for a period of time selected from the range of about one minute to about twenty minutes until the heat curable elastomeric material of the base layer is cured.

41. A method according to Claim 40 wherein said molding step includes molding rib members disposed within and extending transversely across the channel.

42. A method according to Claim 40 wherein the heat curable elastomeric material is styrene-butadiene rubber.





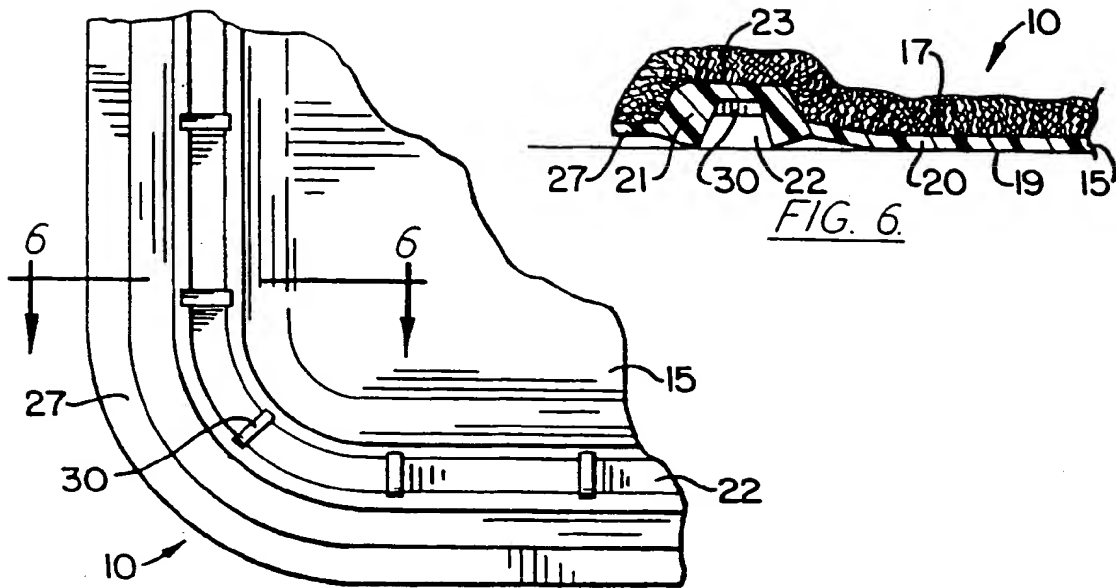


FIG. 5

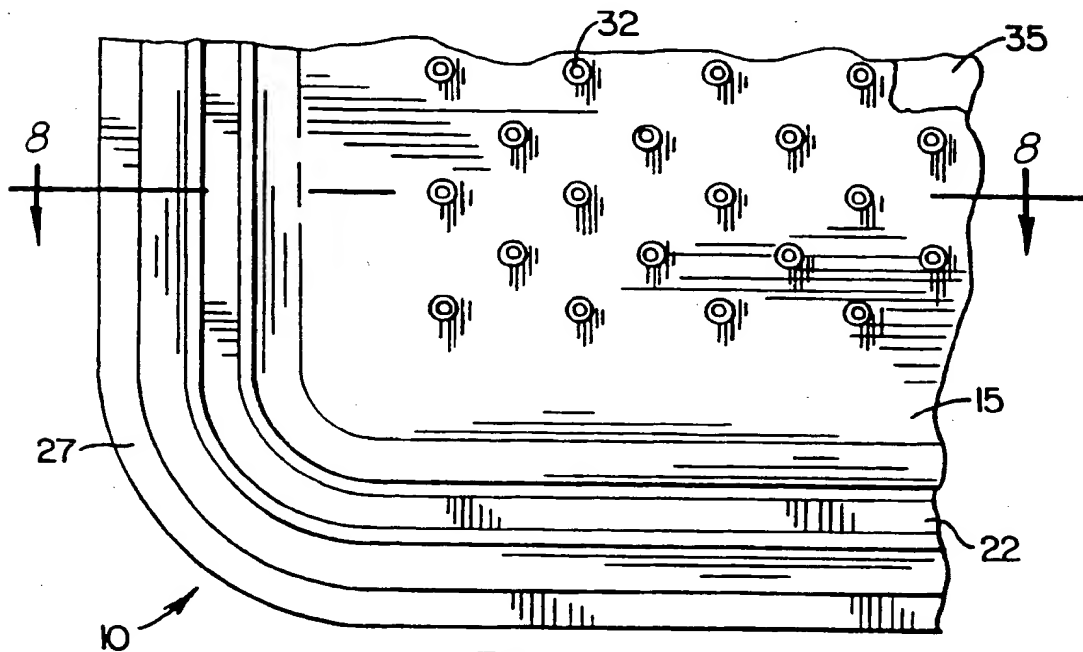


FIG. 7

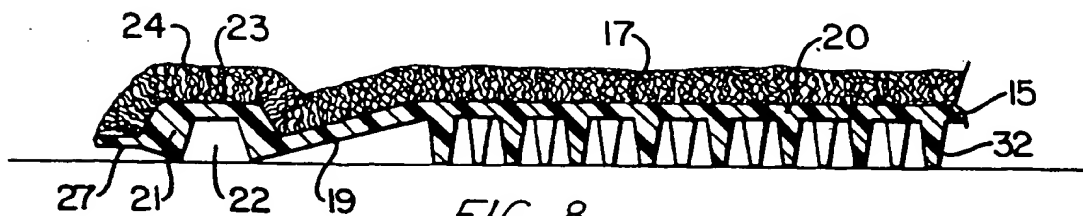


FIG. 8



FIG. 9.

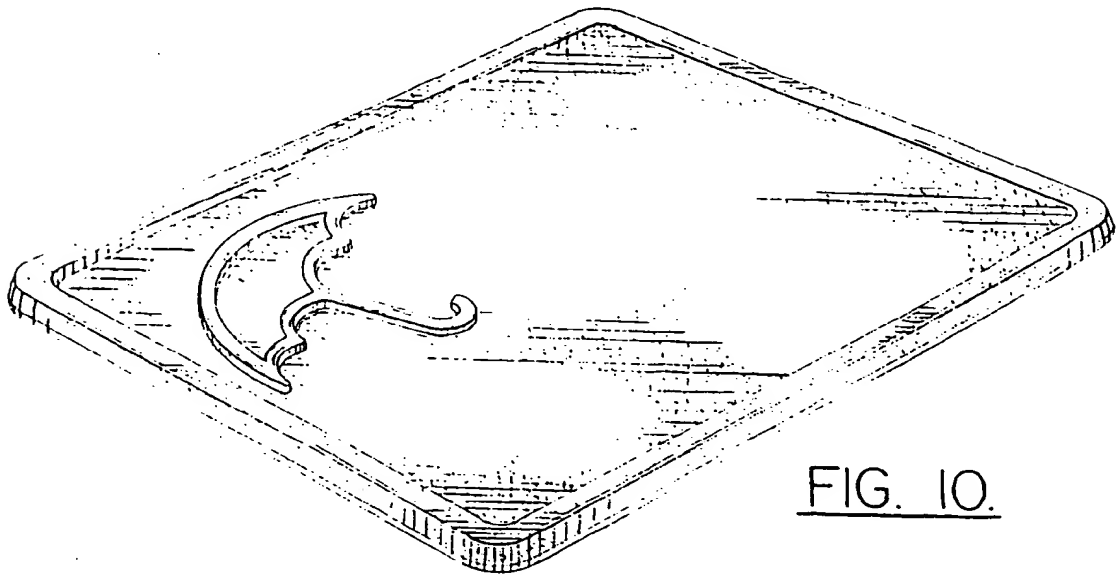


FIG. 10.

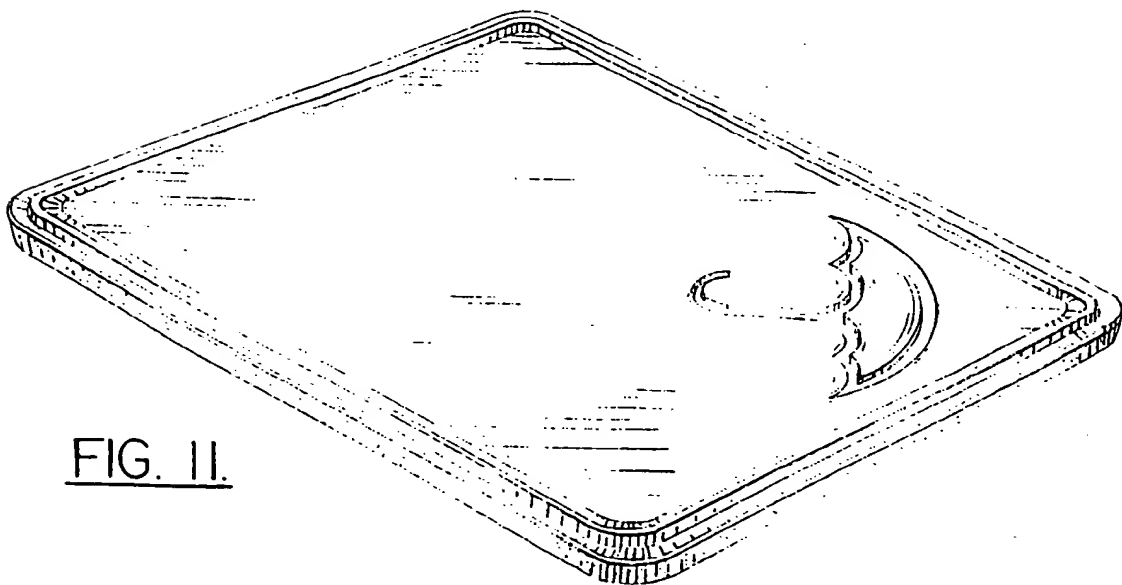


FIG. 11.